

Work Order ID 58953

Thursday, May 20, 2010 10:34:19 AM



Page 1

Item ID: D2989-043

Accept



Setup Start



Revision ID:

Item Name: Basket Lid Assembly

Stop



Start Date: 5/26/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 6/8/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: R

Date: 10-5-20

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2989	Rev D

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

- 1- assemble all ribs in DT9446 jig, weld as per dwg D2989
 - 2- tack weld mesh on basket as per dwg D2989 using DT9446 jig
 - 3- to locate hinges and shims use D2989-041, weld as per dwg D2989
- A/R ER316 S.S. Rod Batch: M113228

10/08/04 (14)
10/08/05 ~~17~~

110

0.00



QC9- Inspect visual per QSI004- Fusion Welds

QC

Memo

0.00

Quality Control

10.09.06

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

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Reference:

Cust Item ID:
Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

130

Pressure Wash
White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00



Powdercoat

Memo

0.00

Powder Coating

Plug holes prior to powder coating

2-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989

1ST COAT

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

***** 2nd coat if necessary*****

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

56108106

=) JU

10/08/09

8:15AM

400°F

8:45AM

9:00AM

400°F

9:30AM

W/O:		WORK ORDER CHANGES					
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Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

g510/08/09 @

150

Identify as per dwg & Stock Location: *G.A*

0.00



Packaging

Memo

0.00

Packaging

w/p 58054

g510/08/09 @

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/08/10 MF 10-8-10

W/O:		WORK ORDER CHANGES					
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Picklist Print

Thursday, May 20, 2010 10:34:51 AM

Page 1

Work Order ID: 58953

Parent Item: D2989-043

Parent Item Name: Basket Lid Assembly

Comments: IPP Rev:I Removed D2989-041 05-11-03 JLM
 IPP Rev:J 08-08-29 revC as per dwg DD verified by:EC
 IPP Rev:K 08-09-24 plug holes prior to powder coating DD verified by:EC
 IPP Rev:L 08-12-02 revD as per dwg DD verified by:

Start Date: 5/26/2010

Required Date: 6/8/2010

Start Qty: 1.00

Required Qty: 1.00

D2221-1	Manufactured	No	100	Each	23.0000	1
Rib						
	<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>	
	WA		23			
	57182		1			
	57499		10			
	58122		12			
D2989-3	Manufactured	No	100	Each	2.0000	1
Rib						
	<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>	
	WA		2			
	57995		2			
D2989-4	Manufactured	No	100	Each	2.0000	1
Rib						
	<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>	
	WA		2			
	57996		2			
D2989-5	Manufactured	No	100	Each	6.0000	2
Rib						
	<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>	
	WA		6			
	57596		2			
	58061		4			

SY 10/08/04
 B60172 → ①
SY 10/08/04
 B60552 → ①
SY 10/08/04
 B60551 → ①
SY 10/08/04
 B60555 → ②

W/O:		WORK ORDER CHANGES					
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 IPP Rev:L 08-12-02 revD as per dwg DD verified by:

Start Date: 5/26/2010

Required Date: 6/8/2010

Start Qty: 1.00

Required Qty: 1.00

D3182-1	Manufactured	No	100	Each	8.0000	2	
Hinge							
		<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>		
		WA		8			
		57602		8			
D3442-3	Manufactured	No	100	Each	12.0000	2	
Shim							
		<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>		
		WA		12			
		53137		4			
		56204		8			
D3827-041	Manufactured	No	100	Each	10.0000	1	
Rib Assembly (Inboard)							
		<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>		
		WA		10			
		57219		4			
		57802		6			
D3832-5	Manufactured	No	100	Each	5.0000	1	
Mesh (Lid)							
		<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>		
		WA		5			
		57603		2			
		57941		3			

M 10/08/04
 B60176 → ②

M 10/08/04
 B60550 → ②

M 10/08/04
 B59982 → ①

B60132 → ① M 10/08/04

Thursday, May 20, 2010 10:34:51 AM

Shop Packet Print

Page 2

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 IPP Rev:L 08-12-02 revD as per dwg DD verified by:

Start Qty: 1.00

Required Qty: 1.00

D3833-5	Manufactured	No	100	Each	15.0000	2	
Mesh (Lid End)							
		<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>		
		WA		15			
		53722		9			
		57627		6			
D3838-041	Manufactured	No	100	Each	4.0000	1	
Rib Assembly (Basket Lid, LH)							
		<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>		
		WA		4			
		57831		2			
		58059		2			
D3838-042	Manufactured	No	100	Each	4.0000	1	
Rib Assembly (Basket Lid, RH)							
		<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>		
		WA		4			
		57832		2			
		58060		2			

B59412 @ JH 10/08/04

JH 10/08/04

B60554 → ①

JH 10/08/04

B60553 → ①

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D2989-043 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

D2989-041 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

- NOTES:
1) MATERIAL: N/A
2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: D2989-041 = 26.50 lbs; D2989-043 = 15.50 lbs
8) WELD PER DART QSI 004

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 58953
BS105-20

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	X		D2989-041	BASKET LID ASSEMBLY
2		X	D2989-043	BASKET LID ASSEMBLY
3	1		D2506	LABEL PLATE
4	1		D2512-7	RIB
5	2		D2581	MOUNTING BRACKET
6		1	D2989-3	RIB
7		1	D2989-4	RIB
8		2	D2989-5	RIB
9	2		D2989-13	RIB
10	2	1	D2989-17	RIB
11	2		D2989-19	RIB
12		2	D3182-1	HINGE
13		2	D3442-3	SHIM
14		1	D3827-041	RIB ASSY (INBOARD)
15	1		D3832-3	MESH, BASKET LID
16		1	D3832-5	MESH, BASKET LID
17	2		D3833-3	MESH, LID END
18		2	D3833-5	MESH, LID END
19	1		D3836-041	RIB ASSY (BASKET LID, LH)
20	1		D3836-042	RIB ASSY (BASKET LID, RH)
21		1	D3838-041	RIB ASSY (BASKET LID, LH)
22		1	D3838-042	RIB ASSY (BASKET LID, RH)
23	1		D3852-041	RIB ASSEMBLY
24	1		D3852-042	RIB ASSEMBLY

RELEASED
08/11/18

D	REVISED -041/-043 PARTS LISTS AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); D3836-041 REPLACES D2989-9/-15; D3836-042 REPLACES D2989-10/-15; D3838-041 REPLACES D2989-1/-7; D3838-042 REPLACES D2989-2/-7; D3852-041 REPLACES D2989-11/-1; D3852-042 REPLACES D2989-2; REMOVED D2327-3 (NOW INSTALLED ON D3836 DWG); D2989-9/-10 (NOW ON D3836 DWG); D2989-1/-2/-7/-15 (NOW ON D3838 DWG) AND D2989-11/-12 (NOW ON D3852 DWG). REASON: TO SATISFY "LEAN MANUFACTURING" PROGRAM	MB	08.09.24
C	FRAME MATERIAL WAS 0.060 WALL; MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT AND CURRENT DRAFTING STANDARD	AJS	08.05.20
B	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	PH	05.06.07
A	NEW ISSUE	DS	00.10.27
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DS		
CHECKED	AS	DRAWING NO.	REV. D
MFG. APPR.	AS	D2989	SHEET 1 OF 5
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	BASKET LID ASSEMBLY	NTS
DATE	08.09.24	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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NOTE: Date & initial all entries

8

7

6

5

4

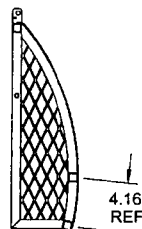
3

2

1

SECTION B-B

D7-2

4.16
REFD3833-3
MESH, LID ENDD3852-041 RIB
ASSEMBLYD3836-041
RIB ASSYTRIM MESH LOCALLY
AS REQUIRED
2 PL

A4-2

D2581
MOUNTING BRACKET
2 PL

B C7-2

D2989-17
RIBD3852-041 RIB
ASSEMBLY
REFD2989-19
RIBTACK WELD EVERY 2ND STRAND
TO INTERNAL FRAME MEMBERSSKIN BASKET LID WITH D3832-3 MESH
TACK WELD EACH END
STRAND TO EXTERNAL FRAMED2989-13
RIBD2989-17
RIBD2989-13
RIBD2512-7
RIBD3852-042 RIB
ASSEMBLY
REF

TYP

TACK WELD MESH TO FRAME
AT EVERY AVAILABLE LOCATION
IN AREA TO BE ANTI-SKID'DBLACK ANTI-SKID
PAINT THIS SECTIONTACK WELD MESH TO LABEL PLATE
AT EVERY AVAILABLE LOCATIOND2989-13 RIB
REF

31.94

32.13
REF96.00
REFD2989-13 RIB
REF

31.94

D2989-041 BASKET LID ASSEMBLY

(MESH SHOWN LOCALLY FOR CLARITY)



2 PL

FILL NOTCH
WITH WELD
9 PL

VIEW A:A B8-2

u1058953

D3833-3
MESH, LID ENDD3852-042 RIB
ASSEMBLYD3836-042
RIB ASSYTRIM MESH LOCALLY
AS REQUIRED
2 PLRELEASED
08/11/18

DESIGN	DS
DRAWN	DS
CHECKED	DS
MFG. APPR.	DS
APPROVED	DS
DE APPR.	DS
DATE	08.09.24

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADADRAWING NO.
D2989

REV. D

TITLE
BASKET LID ASSEMBLY

SHEET 2 OF 5

SCALE
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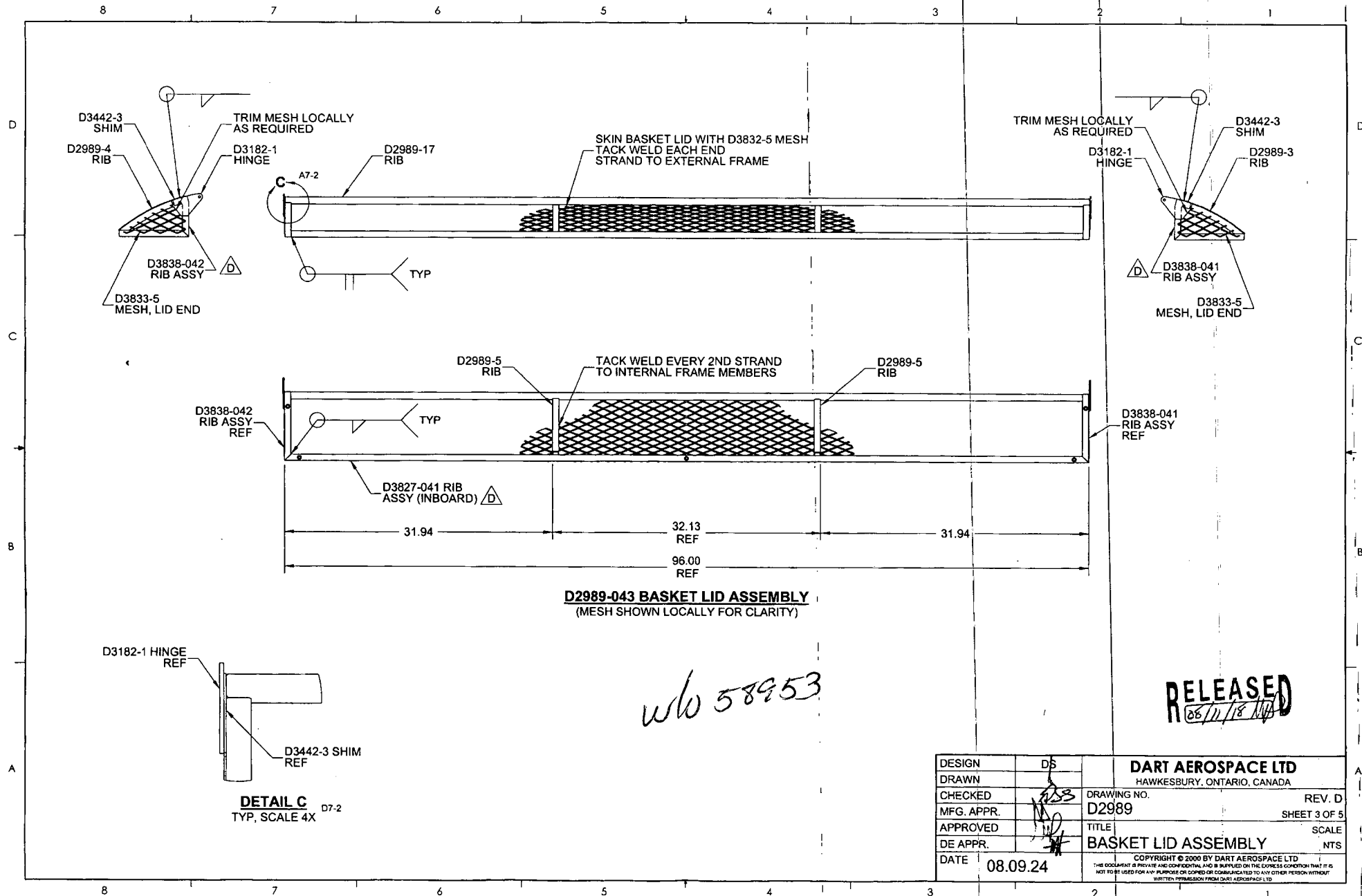
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DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D2989	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
DATE	08.09.24	<small>COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

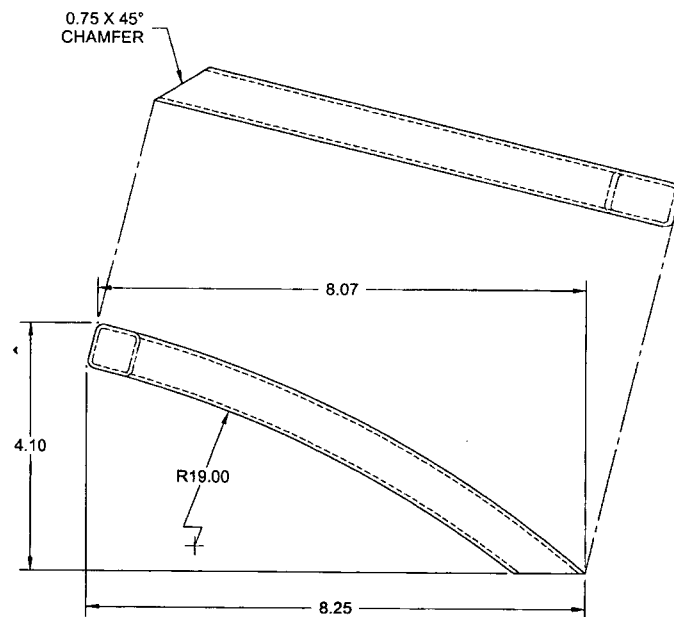
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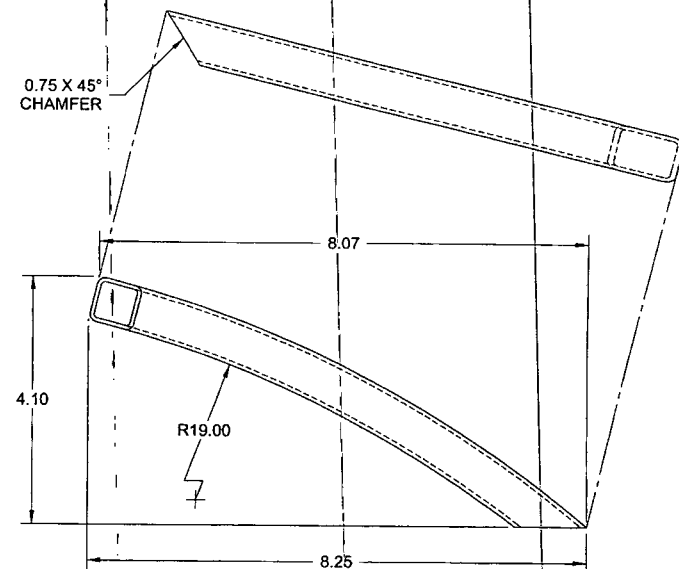
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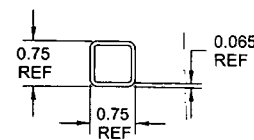


D2989-3 RIB



D2989-4 RIB

w/o 58953



TYPICAL SECTION VIEW

- NOTES:**
- 1) MATERIAL: D3166-3 BASKET HOOP
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 8) WEIGHT: D2989-3/-4 = 0.39 lbs;

RELEASED
08/11/18

DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D2989	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
DATE	08.09.24	<small>COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

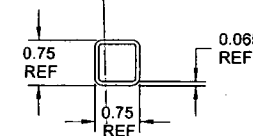
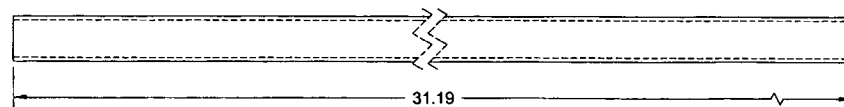
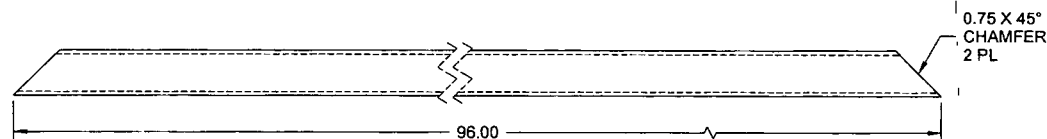
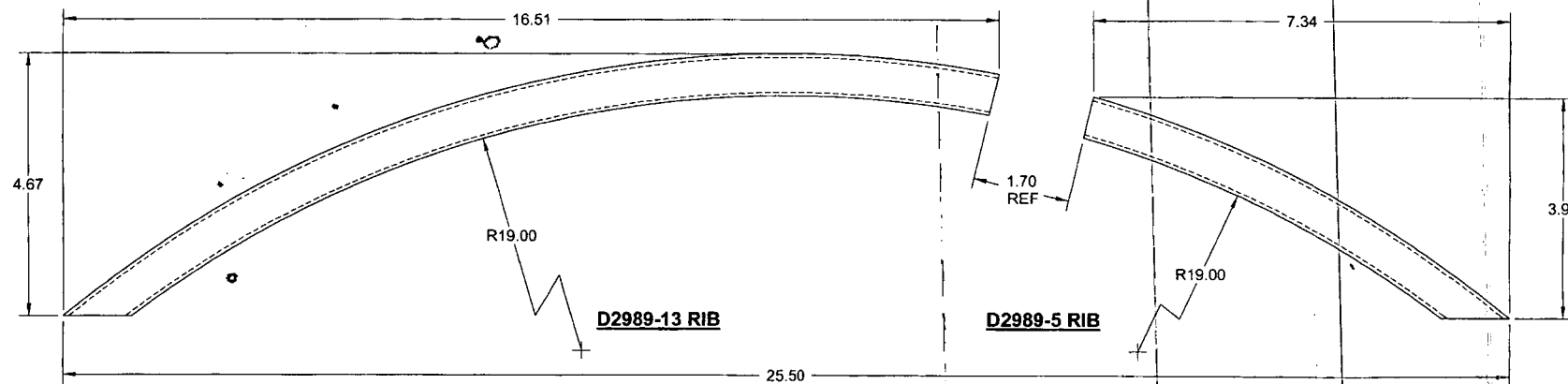
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



TYPICAL SECTION VIEW

w/0 58953

RELEASED
08/11/18

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: D2989-5 = 0.37 lbs; D2989-13 = 0.81 lbs; D2989-17 = 4.57 lbs; D2989-19 = 1.50 lbs

DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>DS</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>DS</i>	D2989	SHEET 5 OF 5
APPROVED	<i>N/A</i>	TITLE	SCALE
DE APPR.	<i>DS</i>	BASKET LID ASSEMBLY	NTS
DATE	08.09.24	<small>COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries